

Radilon® MIXLOY S 32HSA20K 100 NT

Radici Group High Performance Polymers - Polyamide 6 + ABS

General Information

Product Description

PA6/ABS blend, medium viscosity grade. Heat stabilized. Natural colour.

Suitable for parts requiring low moisture absorption and high dimensional stability. Also apt for 3D printing.

General

Additive	• Heat Stabilizer
Features	• Heat Stabilized • Low Moisture Absorption • High Dimensional Stability • Medium Viscosity
Agency Ratings	• EU 2011/65/EC
RoHS Compliance	• RoHS Compliant
Appearance	• Natural Color
Processing Method	• Extrusion
Resin ID (ISO 1043)	• (PA6+ABS)

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density	1.09	g/cm ³	ISO 1183
Water Absorption (Saturation, 73°F, 0.0787 in)	6.4	%	ISO 62
Water Absorption Equilibrium, 73°F, 0.0787 in, 50% RH	2.0	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	363000	psi	ISO 527-1/1A/1
Tensile Stress (Yield)	8700	psi	ISO 527-2/1A/50
Tensile Strain (Yield)	4.0	%	ISO 527-2/1A/50
Nominal Tensile Strain at Break	> 50	%	ISO 527-2/1A/50
Flexural Modulus ²	363000	psi	ISO 178
Flexural Stress ²	13100	psi	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (73°F)	4.3	ft-lb/in ²	ISO 179/1eA
Charpy Unnotched Impact Strength (73°F)	No Break		ISO 179/1eU
Thermal	Nominal Value	Unit	Test Method
Vicat Softening Temperature	266	°F	ISO 306/B50
Melting Temperature ³	428	°F	ISO 11357-3

Processing Information

Extrusion	Nominal Value	Unit
Drying Temperature	176	°F
Drying Time	2.0 to 4.0	hr
Suggested Max Moisture	0.10	%
Cylinder Zone 1 Temp.	500	°F
Cylinder Zone 2 Temp.	500	°F
Cylinder Zone 3 Temp.	509	°F

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Extrusion	Nominal Value	Unit
Cylinder Zone 4 Temp.	518	°F
Cylinder Zone 5 Temp.	518	°F
Adapter Temperature	527	°F
Melt Temperature	527	°F
Die Temperature	527	°F

Notes

¹ Typical properties: these are not to be construed as specifications.

² 0.079 in/min

³ 10°C/min